Work Ord												Page
Item ID: Revision ID: Item Name:	D206-559-0 Bearpaw	21		Accept					Setup	Start Stop		
Start Date: Required Date: Reference:	6/10/2010	Start Qty: 4.00 Req'd Qty: 4.00	* *************************************		Cust Item :	ID:				стор		
Approvals:	Process Pla	an:	Date: <u>/ () </u>			ate:		1	Run	Start Stop		
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp
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QC

8 10/06/14

Quality Control

Memo

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Dart Aerospace Ltd	Dart	Aeros	pace	Ltd
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W/O:			W	ORK ORDER CHANG	GES					4 3
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	egory:	NCR:	Yes	No DQ	A:	Date:	
		esolution:								
NCR:			WORK ORD	ER NON-CONFORM	ANCE	(NCR)			
DATE	STEP	Description of NC			tion B	<u> </u>	Verific	cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Sect	on C	Chief Eng	QC Inspector
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Item ID:

D206-559-021

Accept



Setup Start

Stop



Revision ID:

Item Name:

Required Date: 6/25/2010

Bearpaw

6/10/2010

Start Qty: 4.00

Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Start Date:

Δn	provals	
Λþ	provais	•

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID

Operation Description

QC:

Set Up/ **Run Hours**

Tool ID

Date:

Tool # Plan Code Accept Qty

Reject Reject **Qty** Number

Insp. Stamp

180

Packaging

Packaging

Packaging

Memo

0.00

0.00

Identify and pack for shipping as per PPPD206-559-

Date:_____

021 □ Location:

RUA

190

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/16/8 M10-6-18

Dart	Aeros	pace	Ltd
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W/O:			WORK ORDER CHANGES							
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		Section A	Initial Chief Eng	Action Description Chief Eng		Section C		Chief Eng	QC Inspector	
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Picklist Print Thursday, June 10, 2010 2:47:35 PM	1				Page 1
Work Order ID: 59770					7
Parent Item: D206-559-021					
Parent Item Name: Bearpaw Comments: IPP Rev:C□04.02) 17⊓Dlankaina akan n	JOVINA		Start Date: 6/10/2010	Required Date: 6/25/2010
IPP Rev:D 07-0 IPP Rev:E 08-0		JLM JLM Verified By:EC		Start Qty: 4.00	Required Qty: 4.00
AN4-15A	Purchased	No	160 Each	363.0000 8 \$32	6.14
M		Location	Loc Oty	Loc Code	1
		ST358 114239	363		
	ŕ	114292	3 60	·	
•		. <u>114615</u> 114784	100 200	32	 .
AN4-17A	Purchased	No	160 Each	860.0000 8 32	- - 6-14 D
Bolt		<u>Location</u>	Loc Qty	Loc Code	
		ST359	860	not cout	,
AN960JD416 NAS1149D0463	J. Durchaad	112314 No	860 160 Each	32	
Washer	Fulchased		160 Each	18.0000	14576 10.6.148
C		Location	Loc Oty	Loc Code	
		ST357	18		
D2182B	Manufactured 1	107939 No	18 160 f	315.5812 1.67 6.68	
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Rubber Cushion 5" Mutaral **W & S = N S Wolob M		Location	Loc Oty	Loc Code	
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Dart Aerospace Ltd

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i I									
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Approval Chief Eng	QC Inspector
			:						
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Thursday, June 10, 2010 2:47:35 PM

Work Order ID: 59770

Parent Item:

Comments:

D206-559-021

Parent Item Name:

Bearpaw



IPP Rev:C□04.02.17□Blank size changed□KJ/JLM□

IPP Rev:D 07-01-02

Was K10005

IPP Rev:E 08-01-09 Added Step 2

JLM Verified By:EC

JLM

IPP Rev:F 08-05-05 up a chg DD verified by:EC

Start Date: 6/10/2010

Required Date: 6/25/2010

Start Qty: 4.00

Required Qty: 4.00

D2274

Radius Block

D2438





D2671

Manufactured

Manufactured

Manufactured

Manufactured No

No

No

No

Location

56184

58568

ST017

160

Each

639

639.0000

Loc Code

10-6-14

Location ST010 57714 57912 59108

146 273 220 160 Each

Loc Qty

160

614

14

600

Each

Loc Qty

69.0000

Loc Code

Location Loc Qty ST456 69 55603 69 160

614.0000 Each



Loc Code

0.0000

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W/O:		WORK ORDER CHANGES					п
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Fy 1 3

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed	l:	Date:

	WORK ORDER NON-CONFORMANCE (NCR)										
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Required Date: 6/25/2010

Required Qty: 4.00

Thursday, June 10, 2010 2:47:35 PM

Work Order ID: 59770

Parent Item:

Comments:

r . 1

D206-559-021

Parent Item Name:

Bearpaw

IPP Rev:C□04.02.17□Blank size changed□KJ/JLM□ JLM

IPP Rev:D 07-01-02 IPP Rev:E 08-01-09

Was K10005

No

Added Step 2

JLM Verified By:EC

IPP Rev:F 08-05-05 up a chg DD verified by:EC

_ ... MS21042L4

Purchased

160

Each

3,820,000

Start Date: 6/10/2010

Start Qty: 4.00

Location Loc Oty Loc Code ST139 111827 2 ST300 3818 113422 68 114523 742 114718 1000 114784 2000 9063

QS200-M44S

Purchased

No

160

Each

8.0000

M1/4917 10-6-14 S

Clamp

Location Loc Qty ST450 113288

Loc Code

Dart A	Aeros	pace	Ltd
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Dart Ae	rospace l	Ltd								٠٠ الراد
W/O:		Marie de la companya	W	ORK ORDER CH	ANGES	<u></u>				. ,
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raitito		PAR #:				,				
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DATE	STEP	Description of NC Section A	Corrective Action Section B		Section B		Verification		Approval	Approval
DATE			Initial Chief Eng	Action Descrip	otion	Sign & Date	n & Section C		Chief Eng	QC Inspector
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REFERENCE ONLY

DART AEROSPACE LTD.



D206-559 Page 7 of 13

5.0 PARTS LIST

O11	206 A/B 206 L/L1/L3/L4/407
X D206-559-013 Bearpaw Kit 206 L/L1/	206 A/B 206 L/L1/L3/L4/407
X D206-559-021 Narrow Bearpaw Kit 2	206 A/B 206 L/L1/L3/L4/407
X	06 L/L1/L3/L4/407
X	
X D206-559-033 Wearplate Kit X D407-559-113 Large Bearpaw Kit 200	6 L/L1/L3/L4/407
X D407-559-113 Large Bearpaw Kit 200	6 L/L1/L3/L4/407
4 6 4 6 D2182B050 / RUBBER CUSHION 8 12 8 12 20 D2274 RADIUS BLOCK 2 D2435 19" X 16" BEARPAW 2 D2432F, 19" X 24" BEARPAW 2 D2671 13" X 16" BEARPAW 2 D2672F 13" X 24" BEARPAW 4 6 4 6 D2438 (CLAMP)	O LI II COL COLOR
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4 6 4 6 D2438 (CLAMP	
8 12 8 12 D2529 / WASHER	
6 6 D2732-050 RUBBER CUSHION	
2 D3456-1 WASHER	
2 D3859-041 WEARPLATE	
2 D3860-041 WEARPLATE	
2 D4010-041 BEARPAW ASSEMBLY	/
8 D4011-1 CLAMP, SHORT	
2 D4011-3 CLAMP, LONG	
8 D4011-5 CLAMP, SHORT (OEM)
10 D4012-1 CUSHION	
2 AN4C10A BOLT	
8 12 8 12 8 12 AN4-15A / BOLT	
8 12 8 12 8 12 AN4-17A A BOLT	
4 AN4C13A BOLT	· · · · · · · · · · · · · · · · · · ·
8 AN4C15A BOLT	
8 AN4C17A BOLT	
16 24 16 24 AN960JD416 /WASHER	
8 12 8 12 8 12 MS21042L4 / NUT (OR MS21042-4)	
20 MS21043-4 NUT	······································
8 12 NAS1149D0463J WASHER	
2 QS200M44S /CLAMP	

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Revision: K

Date: 09.11.16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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